

WHAT IS CLAIMED IS:

1. A method of making an easy-open end for a container, comprising steps of:
 - (a) providing a can end having a peripheral edge and a panel, said panel having opposing first and second sides with said first side adapted to face toward the inside of a container when said end is affixed thereto;
 - (b) forming first and second grooves in said panel spaced from said peripheral edge, said grooves extending below the level of said first side to form inner and outer beads;
 - (c) forming a central bead in said panel between said first and second grooves, said central bead extending above the level of said second surface;
 - (d) forming a score along said central bead on said second side of said panel;
 - (e) forcing said inner and outer beads toward each other and then toward said first surface while forcing said central bead toward said second surface, this step being performed in such a manner that said central bead elastically deforms at said score; and
 - (f) fixing a pull-tab to said end, said pull-tab having means for severing said end along said score.
2. A method of making an easy open end for a container according to claim 1, wherein step (e) is performed in such a manner that said central bead will bend at said score.
3. A method of making an easy open end for a container according to claim 2, wherein step (e) is performed in such a manner that said central bead will bend concavely about said score.
4. A method of making an easy open end for a container according to claim 1, wherein said step of forming a score along said central bead on said second side of said panel comprises forming a score having a notched bottom, whereby elastic deformation of said central bead at said score during step (e) is promoted.

5. A method of making an easy open end for a container according to claim 4, wherein said notched bottom is tapered to a continuous V-shaped recess.
6. A method of making an easy open end for a container according to claim 1, wherein step (b) is performed by forming first and second concentric grooves in said panel spaced from said peripheral edge.
7. An easy-open end that is made according to claim 1.
8. A method for forming a pull-tab removable end, said method comprising the steps of:
 - (a) providing a metallic can end;
 - (b) forming inner and outer concentric beads in said end extending away from said end, the inner bead extending a greater distance away from said end than said outer bead;
 - (c) forming a notched score between said inner and outer beads;
 - (d) forcing said inner and outer beads toward each other and toward the plane of said end until said beads abut said end and said can end bends about said notched score; and
 - (e) fixing a pull-tab to said end, said pull-tab having means for severing said end along said score.
9. A method for forming a pull-tab removable end according to claim 8, wherein said notched bottom is shaped so as to define a score bottom that is tapered to a continuous V-shaped recess.
10. An easy open end that is made according to claim 8.
11. An easy open end for a container, comprising:
an end panel having a score defined therein defining a removable end panel portion;

a first double fold defined adjacent to and positioned radially inward from said score, said first double fold defining beneath said score a first outwardly projecting extending cut protection bead;

a second double fold defined adjacent to and positioned radially outward from said score, said second double fold defining beneath said score a second inwardly projecting cut protection bead;

said end panel being elastically deformed in an area near said score so as to define a concave depression about said score; and

a pull-tab affixed to said end panel.

12. An easy open end for a container according to claim 11, wherein said score is notched so as to define a score bottom that is tapered to a continuous V-shaped recess.

13. An easy open end for a container according to claim 12, wherein said continuous V-shaped recess is shaped so as to have an edge radius that is no greater than 0.0005 inches.

14. An easy open end for a container according to claim 11, wherein said concave depression extends for a full length of said score.